

Date: Friday, 2/23/2007 2:00:30 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PANEL	
Job Number	: 30961		Part Number	: D33307	
Estimate Number	: 10908		Drawing Number	: D3330 REV B1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/23/2007 S.O. No. : N/A		Drawing Revision	: B1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 3/20/2007	
Previous Run	: 28627		Qty:	8	Um: Each
Written By					
Checked & Approved By					
Comment	: Est. 05.01.13 New issue KJ/JLM Est Rev.B Now on Waterjet 06-09-25 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S125	1010-1025 sheet .125
Comment: Qty.: 0.7971 sf(s)/Unit Total : 6.3768 sf(s) 1010-1025 sheet .125 Batch: <u>M 07 03 19</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3330 Dwg Rev: <u>B1</u> <u>M 07 03 19</u> 3 Prog Rev: <u>B1</u>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>M 07 03 20</u> 3		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>Ep 07/08/20</u> (X3)		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr Form as per Dwg D3330 <u>SB 07/08/20</u> (3)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/08/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 2:00:30 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 30961

Part Number: D33307

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

en 07/08/20 X 3

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS23

07.08.20

③

8.0 QC21

FINAL INSPECTION/W/O RELEASE



③

Comment: FINAL INSPECTION/W/O RELEASE

P 07/08/21

Job Completion



U 07.08.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30961
Description: Frame Assembly	Part Number:	D3330-7
Inspection Dwg: D3330	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>ML</u>	Audited by: <u>LP</u>	Prototype Approval:	N/A
Date: <u>07/08/20</u>	Date: <u>07/08/20</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.27	New Issue	KJ/JLM	SM



DESIGN

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DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

D3330

REV. B

SHEET 1 OF 9

DATE

05.02.26

TITLE

FRAME WELDMENT

SCALE

1:8

A

04.12.16

NEW ISSUE

B

05.02.26

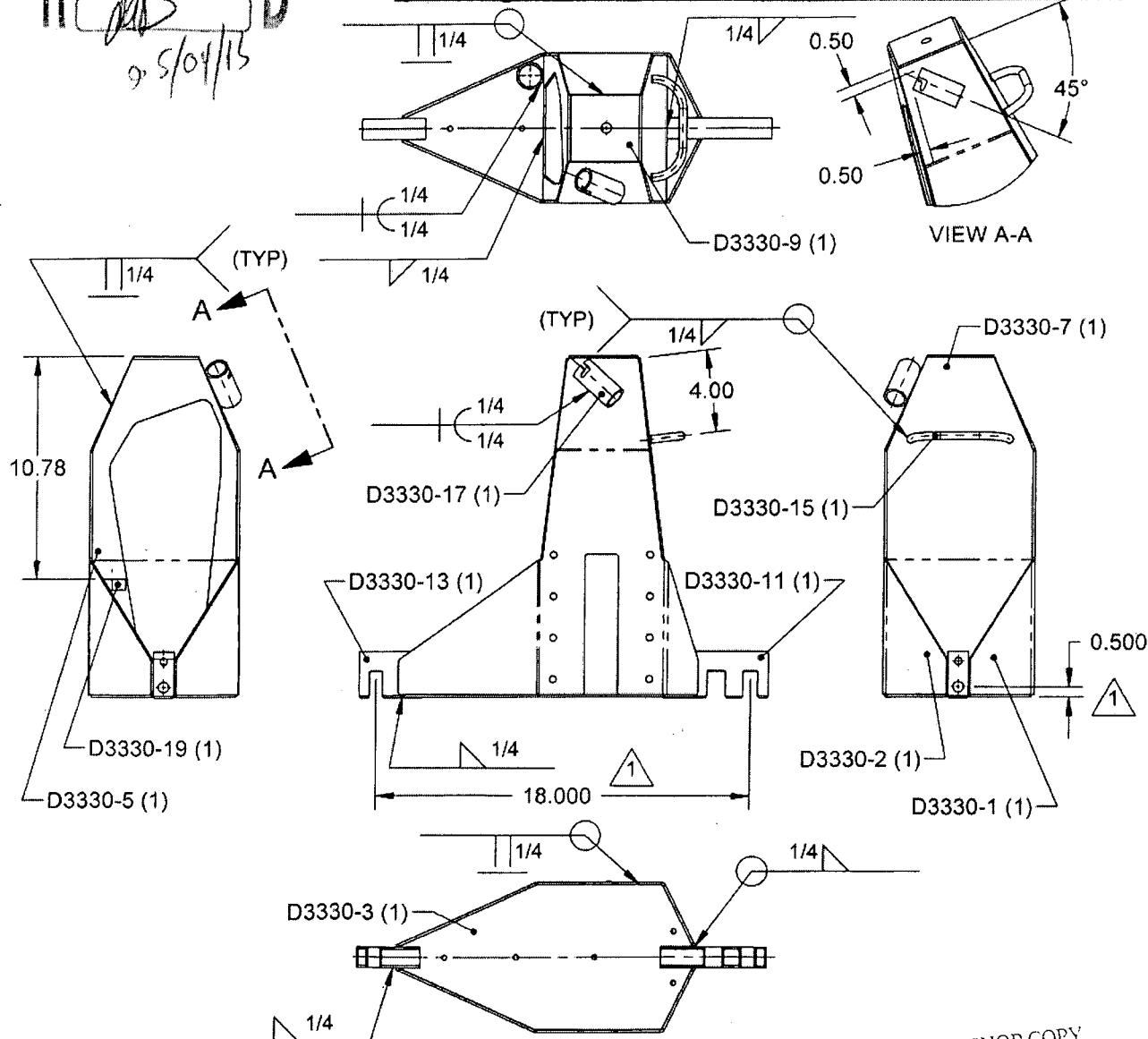
REDESIGN

B1

05.07.04

ADD 1.605 DIM.

RELEASED
9/5/04/15



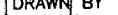
D3330-041 FRAME WELDMENT

NOTES:

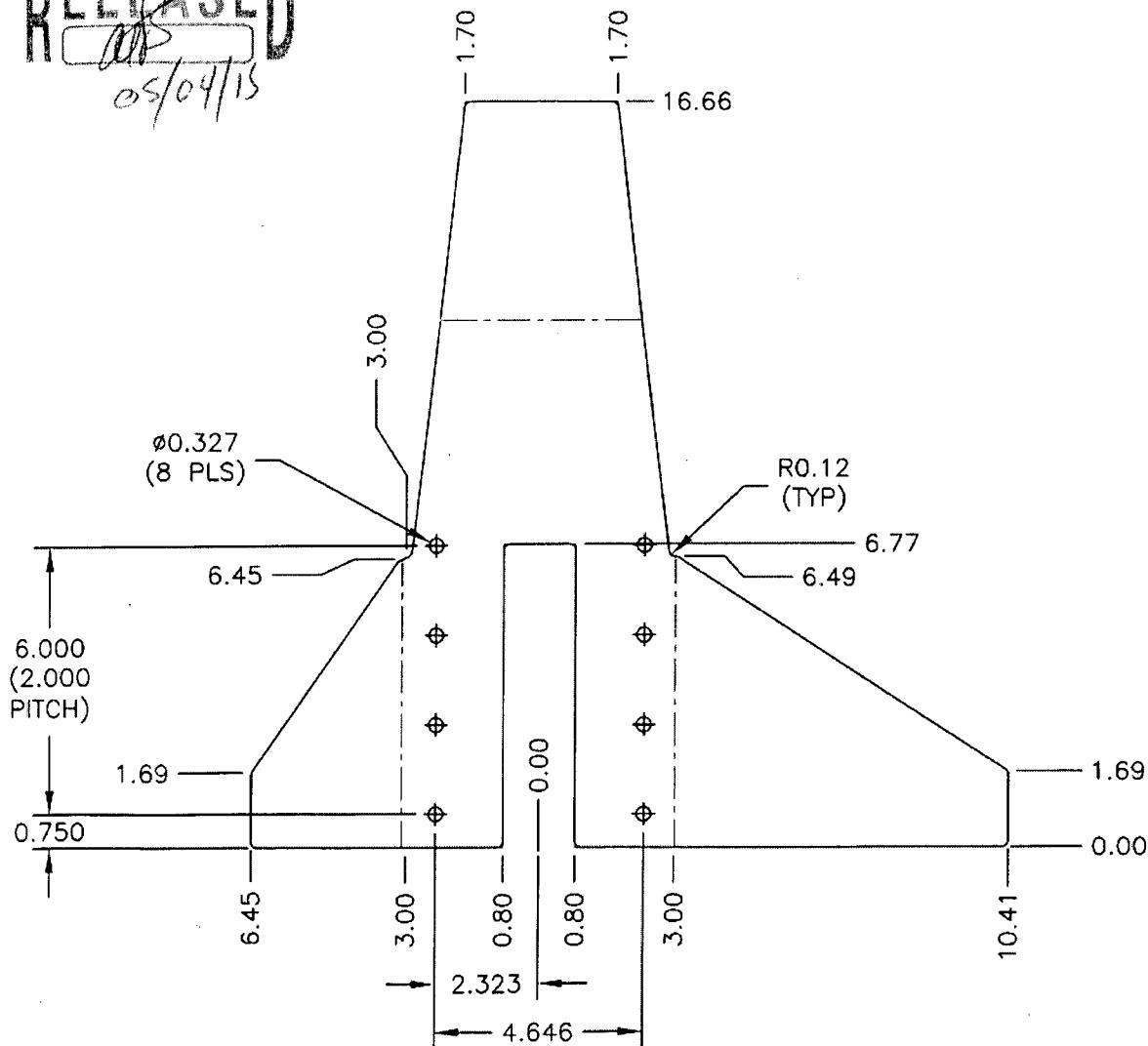
- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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NO 30961



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DATE 05.02.26	TITLE FRAME WELDMENT		SCALE	1:4

RELEASED
05/04/13



D3330-1 PANEL

NOTES:

NOTE:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
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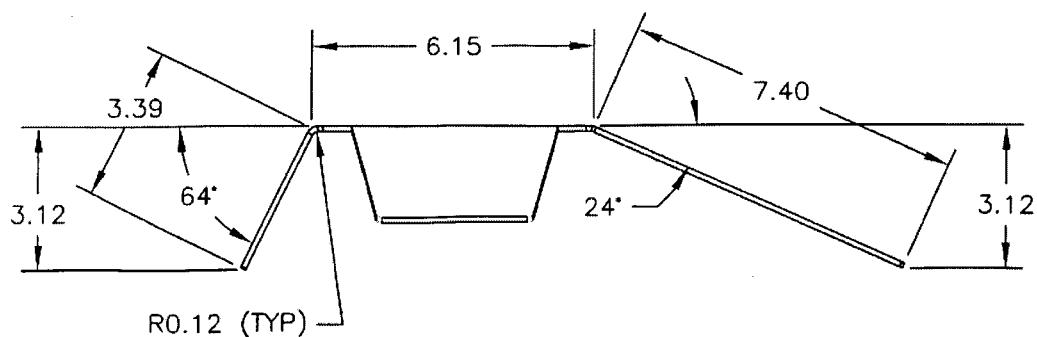
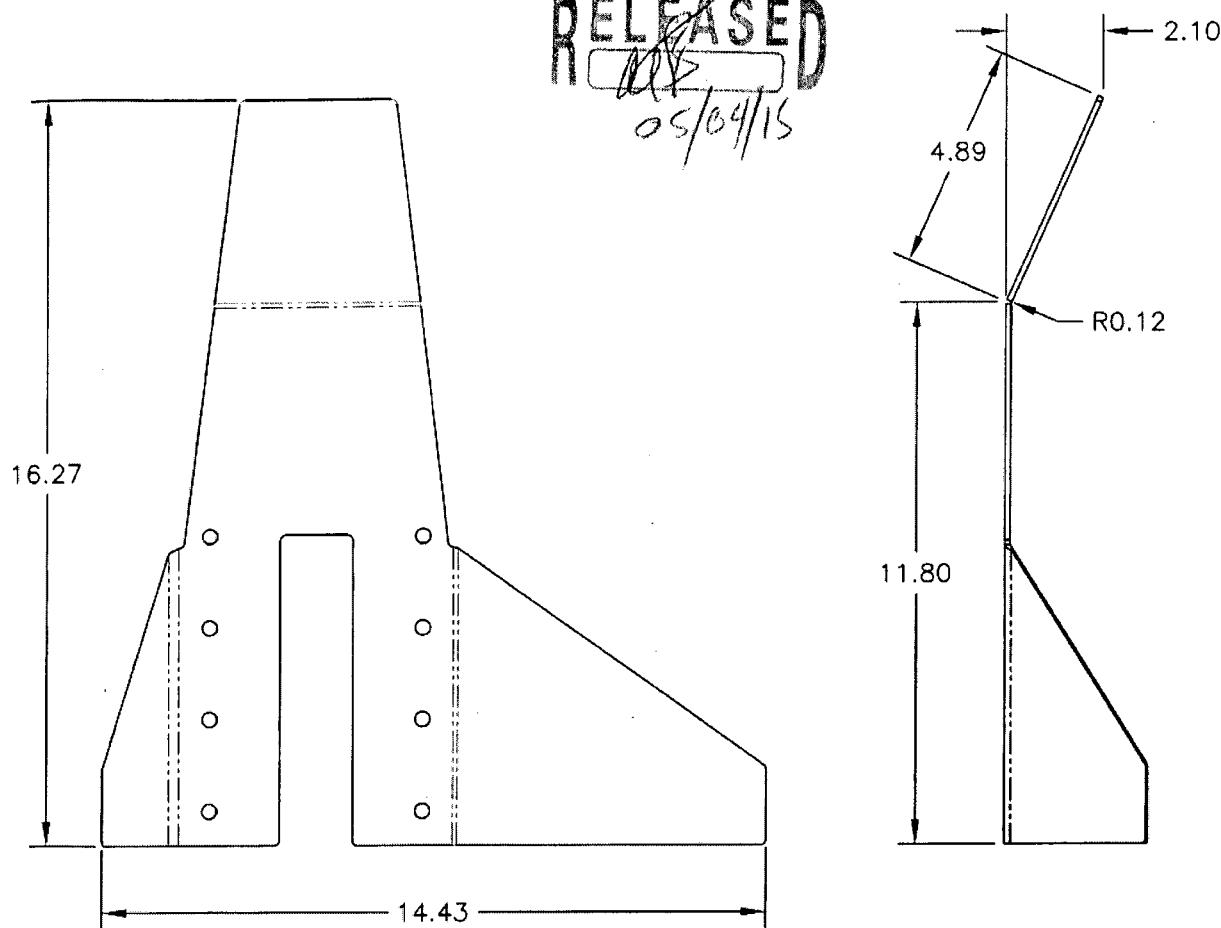
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
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		D3330	SHEET 3 OF 9
DATE	TITLE	SCALE	
05.02.26	FRAME WELDMENT	1:4	

RELEASED
05/09/15



D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

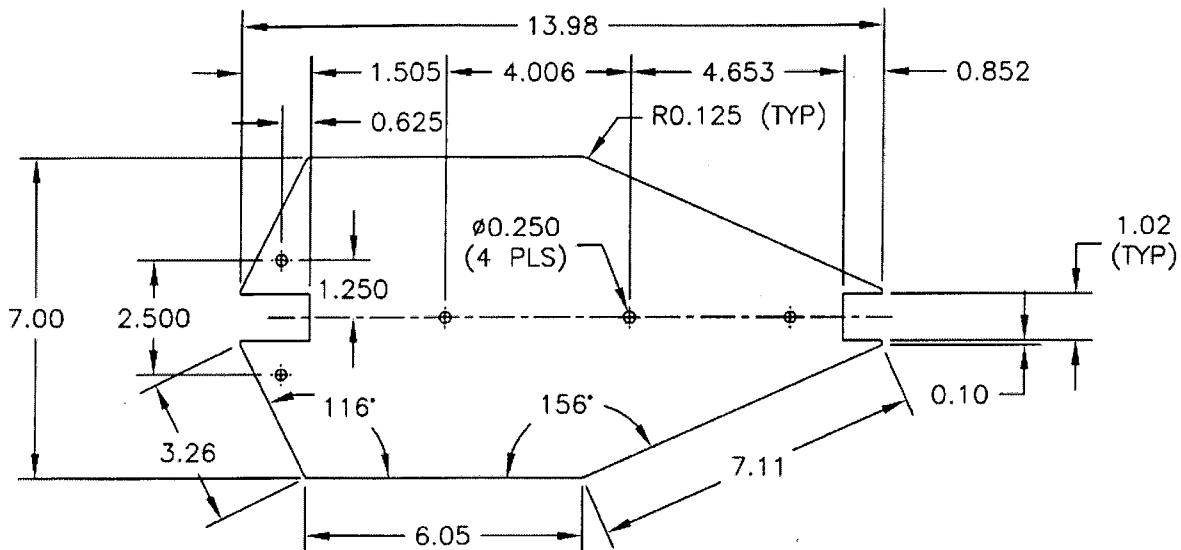
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		D3330	SHEET 4 OF 9

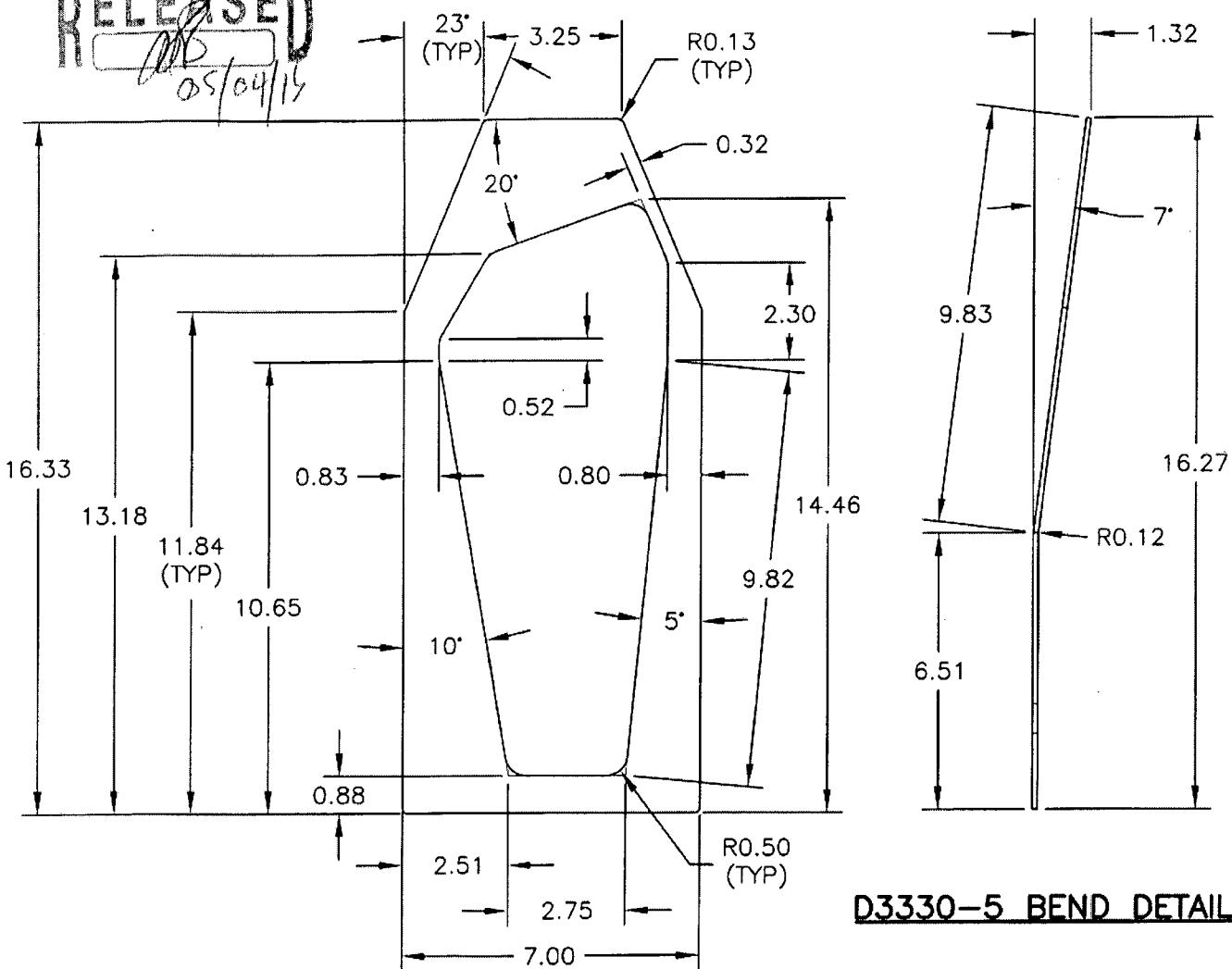
DATE
05.02.26TITLE
FRAME WELDMENTSCALE
1:4**RELEASED**
05/04/13**D3330-3 PLATE**NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK) SUBJECT TO AMENDMENT WITHOUT NOTICE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:14

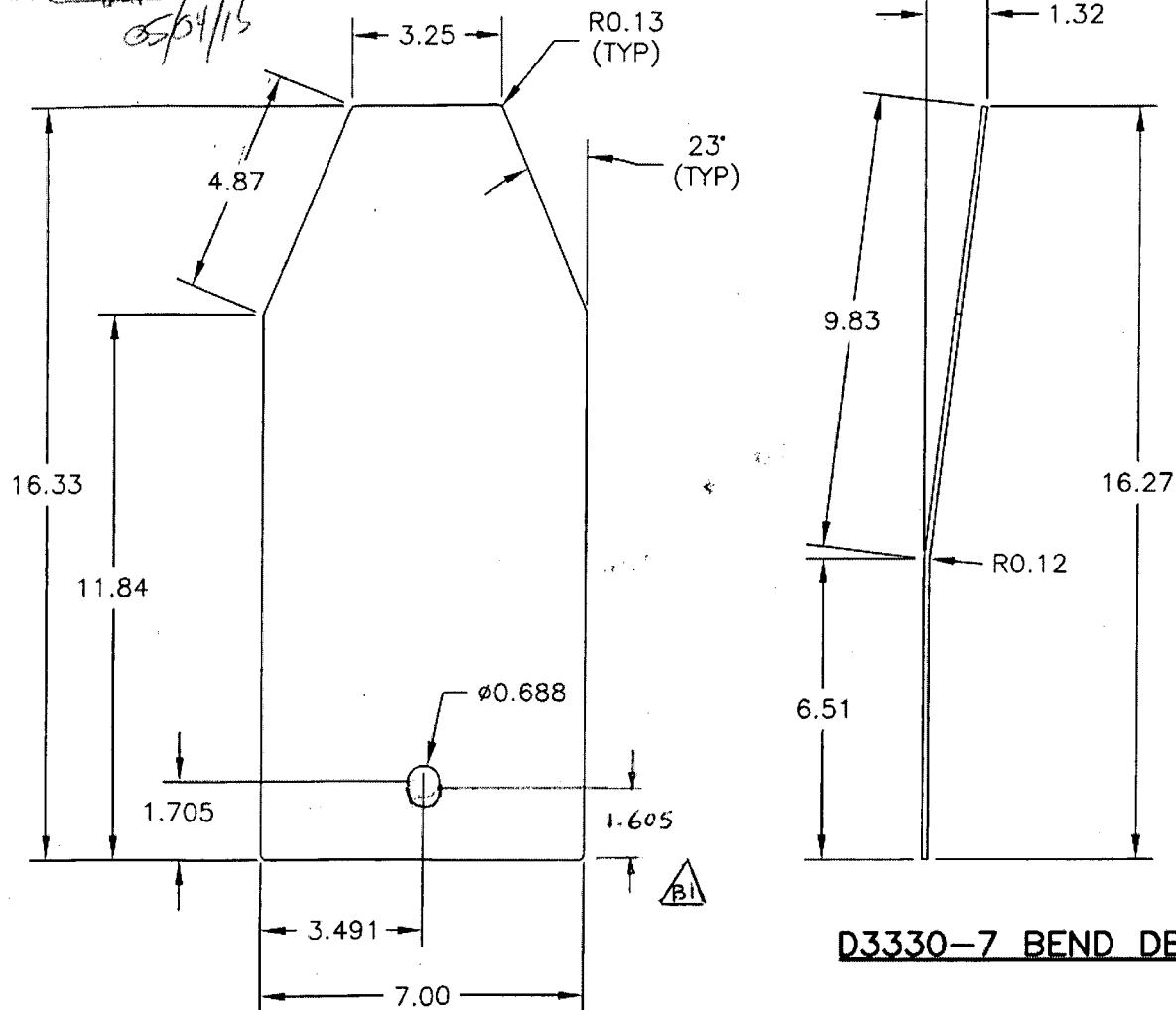
RELEASED
MD
05/04/13**FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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		D3330	SHEET 6 OF 9
		TITLE	SCALE
		FRAME ASSEMBLY	1:4

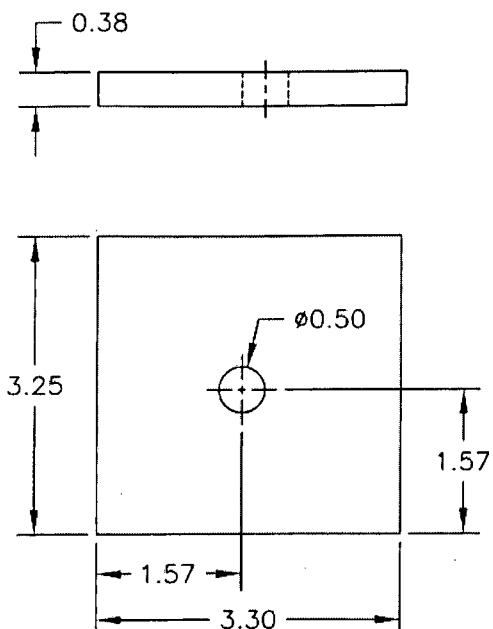
RELEASED
SP4/13**FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 ENGINEERING 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125" THICK) ROLLED COPY
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

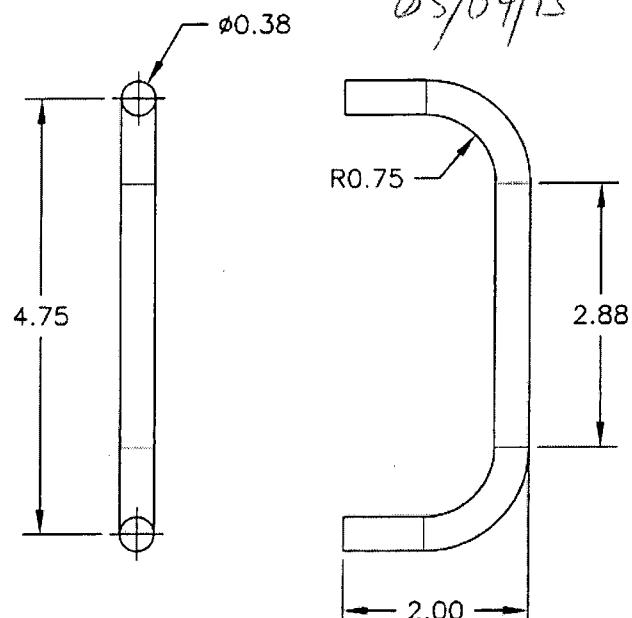
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RF	MM	D3330	SHEET 7 OF 9
DATE	05.02.26	TITLE	SCALE
		FRAME WELDMENT	1:2



△ D3330-9 TOP PLATE



△ D3330-15 HANDLE

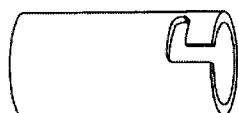
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

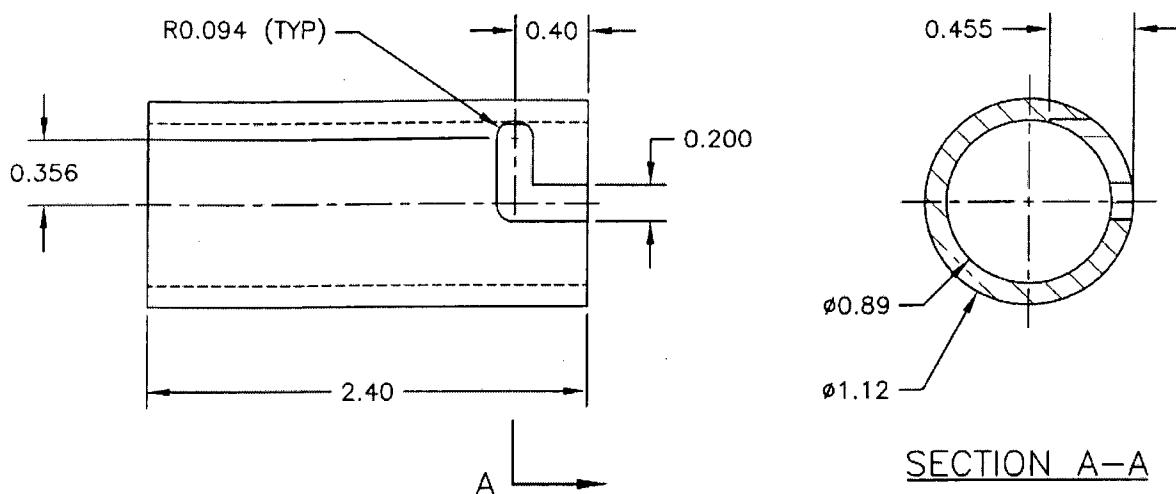
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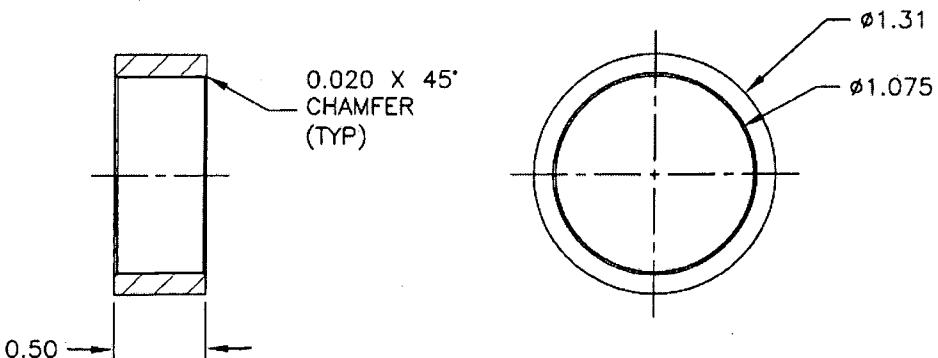
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:1



RELEASED
*MP
05/02/05*



D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

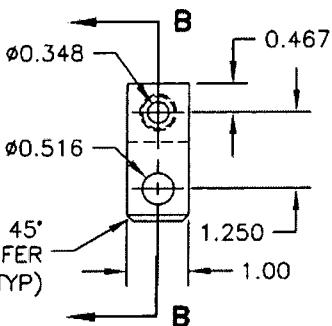
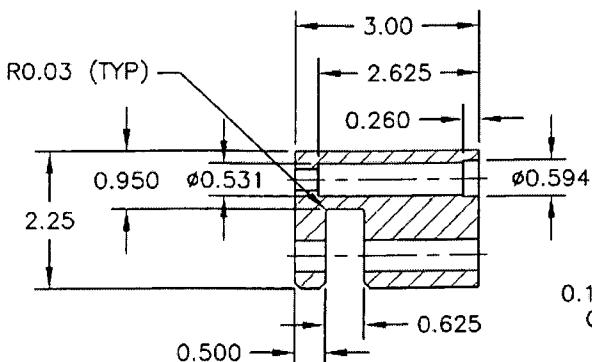
NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097
(REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

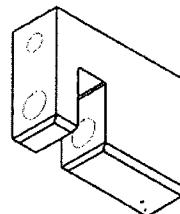
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DATE 05.02.26	DRAWING NO. D3330		REV. B SHEET 9 OF 9
		TITLE FRAME WELDMENT	SCALE 1:3

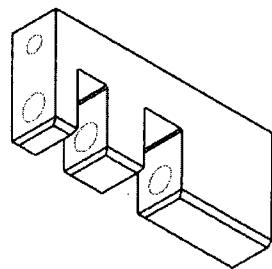
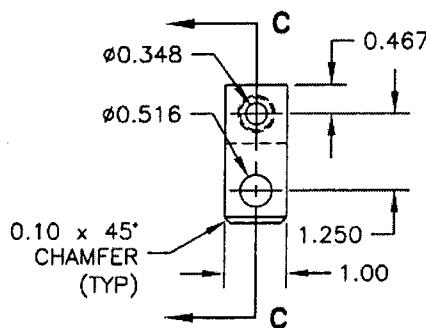
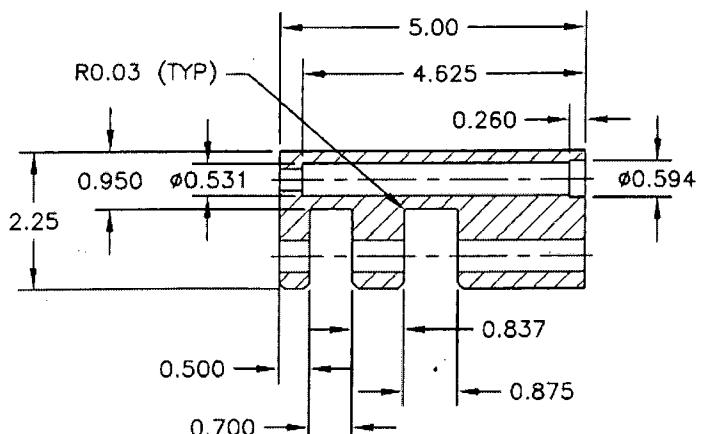


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05/04/15



SECTION B-B

D3330-13 SHORT PIN BRACKET



SECTION C-C

D3330-11 LONG PIN BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL
(REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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